NCR: Y	es / No			•	WORK ORDER NON-	CON	IFORM	MANCE / UP	DATE	04.61	D-4-	
					I	Т				QA Closed:	Date	<u>:</u>
Work Ordei	r:				DISPOSITION	I			AGAINST D	EPARTMENT,	/PROCESS	
					Rework	7		Skid-tube	Crosstube	7	Water Jet	Engineering
Part No	o				Scrap		ı	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is		Therm	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	0				Work Order Update	╛┃		Large Fab	Composite	_	Supplier	_
Root		I		Descri	ption of work order update		nitial	Act	ion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	i	ief Eng		iption	Date	Verification	QC Inspector
Ooc/Data	Date	эсер	Qty		or reon comormance	-	ici ciig	Desci	iption	Date	Vermedien	Qe mspector
quip/Tooling												
perator	1											
/laterial												
etup		:										
Other												
rocess		-										
iupplier												
raining	7					1					:	
Inapproved												
					F	AUL	T CATE	GORY				
Landin	g Gear				General		ı		_	_	_	_
	Bending				Bend	Ш	Grain		<u> </u>	Ovalized	L	Pressure/Forced
	Centre No	ot Concer	ntric to	o/s	BOM/Route	Ш	Hardwa	re		Over/Under	-	Temperature/Cure
L	Cracks			_	Broken/Damaged	\vdash	•	on Incomplete	_	Part Incorre	ļ	Weld
	Crushed/	Crimped			Burrs	Ш	Instruct	ions Incomplete/U	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	enance		Part Moved		
	Heat Trea	at		<u> </u>	Countersink	Ш	Mislabe	eled	L	Positioned V	Vrong	_
	Inspectio		Tube		Cut Too Short		Misread	d .	L	Power Loss/	Surge	Other
	Ripples ir				Drill Holes .	Ш	Offset					
	Torque W	/aves in E	Extrusio	n L	Drawing		Out of 0	Calibration				
!	Turning S	equence			Finish		Out of S	Sequence				
	Wave/Tw	ist in Tul	ре		Folio		Outside	Dimensions				

DQA:

Date:

Work Order ID April-30-13 2:39:54 Pl			*1010	89*					Page 2
Item ID: D2574 Revision ID: Item Name: Saddle,	Aft In 205	Acce	pt 🖈	N9000	7401	೧೧ *	Setup Start	ı VI.	S1* S2*
Start Date: 5/06/13 Required Date: 5/06/13 Reference:		*12* *12*		Cust Item II) :				
			ooling: PC (Y/N):		te:		Run Start Stop	171	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool# P	lan Accept ode Qty	Reject Qty	Reject Number	Insp. Stamp
120 * 120 * QC Quality Control	QC2- Inspect parts off machine Memo		0.00	re 2013	5-06-ZLG Obe/27	' <i>12</i>	L 18_		
130 *130 QC Quality Control	QC8- Inspect parts - second che		0.00	(3.6	-29	12	4		(3-89 (1)(.
140 *14 HandFinish	Chemical Conversion Coat per Memo		0.00			12	26	13.	7-2

Hand Finishing

										DQA:	Dat	e:
NCR: Ye	es / No				WORK ORDER NON	-CON	IFORN	MANCE / UP	DATE	QA Closed:	Dat	e:
Work Ordei	·		,		DISPOSITION				AGAINST DE	EPARTMENT,	/PROCESS	
Part No	0				Rework Scrap Use-as-is		Therm	Skid-tube Machining noforming	Crosstube Small Fab Finishing	⊣	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	0			 	Work Order Update	┚┃		Large Fab	Composite	_	Supplier	
Root Cause	Date	Step	Qty		iption of work order update or Non-conformance		nitial ief Eng		tion cription	Sign & Date	Verification	QC Inspector
oc/Data quip/Tooling perator Material etup other rocess upplier raining								,				
*,				-		FAUL	T CATE	GORY				
Landin	Bending		·		General Bend		Grain			Ovalized		Pressure/Forced
	Cracks Crushed Cuffs Heat Tre	lot Conce /Crimped eat on Strip in		O/S	BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short			on Incomplete ions Incomplete/ nance led	/Unclear	Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing (Temperature/Cure Weld Wrong Stock Pulled Other
 	Ripples i	* .	Extrusio	n	Drill Holes Drawing		Offset Out of (Calibration	.			Pottici

Wave/Twist in Tube

Folio

Work Ord e April-30-13 2:3		1089		*101	1089*					Page 3
Item ID: Revision ID: Item Name:	D2574 Saddle, Aft In	205	A	Accept	*N90	በበ4በ <i>՝</i>	100*	Setup	Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	5/06/13 : 5/06/13	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Iter					
Approvals:		n: Date	e:	Tooling: SPC (Y/N):		Date:		Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center I	D	Operation Description White Gloss(Ref:4.3.5.1) per QS	1005 4.3-Alum	Set Up/ Run Hours 0.00	Tool II		Code Qty	Qt	y N	Reject Insp. Number Stamp
150 Powdercoat	1	Memo START TIME: OVEN TEMPERAT	9713) _{0.00}	· ·		12 Xy	f M.	If.	13/07/03
Masp	900	FINISH TIME:	G-4		‡					
*160 *160* QC		QC3- Inspect Part Finish Memo		0.00	. •		12	Ø_	<u> 13</u> .	7-3. 34
Quality Control					· · ·					32
170 *17 Packaging		Identify as per dwg & Stock Loc	ation: <u>5T442</u>	0.00	:		12	y ,	M.	hl. 13-07-0
Packaging		MEHIO			!				ι	

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										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NO	N-CO	NFORM	MANCE / UP	DATE			
		<u> </u>								QA Closed:	Date:	
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
					Rewor	k		Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.				Scra	р		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-i	is	Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	lo				Work Order Updat	e		Large Fab	Composite]	Supplier]
										,		
Root				Desc	cription of work order upda		Initial		tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Cł	nief Eng	Desc	cription	Date	Verification	QC Inspector
Ooc/Data	-											
quip/Tooling												
)perator												
Material	_					l	•					
etup Other												
Process	-		1			Į.						
Supplier												
raining									-		·	
Jnapproved	7											
						FAUI	LT CATE	GORY		1	1	
Landir	ng Gear				General							_
	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to (o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
ļ	Cracks			L	Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
		/Crimped		_	Burrs	_	Instruct	ions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled
* 4.4	Cuffs				Contamination	<u> </u>	Mainte			Part Moved		
	Heat Tre			L	Countersink	ļ	Mislabe		_	Positioned V		7
	_	on Strip in	Tube	-	Cut Too Short	L	Misread	d	L_	Power Loss/	Surge	Other
	Ripples i				Drill Holes	_	Offset					
	—	Waves in I		^	Drawing		-1	Calibration				
	ITurning	Sequence		1	lFinish	1	IOut of 9	Sequence				

Wave/Twist in Tube

Folio

Work Ord April-30-13 2:3	•			*101	1089*						, 		Page 4
Item ID: Revision ID: Item Name:	D2574 Saddle, A	Aft In 205		Accept	*N90) ((<u>140</u>	100)*	Setup	Start Stop	*N *N	S1* S2*
Start Date: Required Date	5/06/13 : 5/06/13		*12* *12*		Cust It) :			•			
Approvals:		s Plan:	Date:			Dat		- 		Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center I 180 *180* QC Quality Control	D	Operation Description QC21- Final Inspection - Memo	Work Order Release	Set Up/ Run Hours 0.00	Tool	ID	Tool#	Plan Code	Accep Qty	t Re Qt	•	Reject Number	Insp. Stamp WF 3-7-4

					•					DQA:	Date	:
NCR: Y	es / No				WORK ORDER NON	-COI	NFORM	MANCE / UP	PDATE	QA Closed:	 Date:	
										·····		,
Work Orde	r:				DISPOSITION				AGAINST DE	EPARTMENT,	/PROCESS	
Part N	o.				Rework Scrap		ľ	Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	o				Use-as-is Work Order Update		Thern	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descri	I ption of work order update		I Initial	Ac	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	cription	Date	Verification	QC Inspector
occ/Data quip/Tooling Operator Material Setup Other Process Supplier Fraining Jnapproved											·	
эпарргочеа		1	1	L		FAUI	LT CATE	GORY	_ .			
Landin	g Gear				General							
	Bending Centre N Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in	'Crimped at on Strip in n Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misreae Offset	ion Incomplete ions Incomplete, enance eled	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
ŀ	Torque V			n -	Drawing Finish	-	4	Calibration Sequence	•			
1	[' W' ' ' ' ' ' ' ' ' ' ' ' ' ' ' ' ' '	,			printer.		10000					

Wave/Twist in Tube

Folio

Work Order ID:

101089

Parent Item:

D2574

Parent Item Name:

Saddle, Aft In 205

Start Date: 5/06/13

Required Date: 5/06/13

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev: I As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-005 Saddle Billet		Manufactured	No			110	Each	57.0000	1	12			
				Location		Loc Qty	<u>L</u> c	oc Code					
				MAT041		2							
•				7683	8	2	•						
				MAT044		53							
				7987	4	7						,	
				9792	2	6	i		-		Our	1 _ /-	//
				→ 9921	8	40				2	CMY	13/0	e/29
				MAT045		2							
				8896	0	2	i						

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										DQA:	Date:	
NCR:	⁄es	/ No				WORK ORDER NON-C	ONFORM	MANCE / UP	DATE	QA Closed:	Date:	
Work Orde	er:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N	- _ اo					Rework Scrap	1	Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	۷o	**************************************	· · · · · · · · · · · · · · · · · · ·			Use-as-is Work Order Update		noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root					Descri	ption of work order update	Initial	Ac	ction	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Ooc/Data												
quip/Tooling												
Operator												
Material						·	:					
etup		_										

Γ	Bending		Bend	Grain	\Box	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S		BOM/Route	Hardware		Over/Under tolerance	Temperature/Cure
Γ	Cracks	Г	Broken/Damaged	Inspection Incomplete		Part Incorrect	Weld
	Crushed/Crimped		Burrs	Instructions Incomplete/Unclear		Part Lost/Missing	Wrong Stock Pulled
	Cuffs		Contamination	Maintenance		Part Moved	
	Heat Treat		Countersink	Mislabeled		Positioned Wrong	
	Inspection Strip in Tube		Cut Too Short	Misread		Power Loss/Surge	Other
	Ripples in Bend		Drill Holes	Offset			
	Torque Waves in Extrusion		Drawing	Out of Calibration			
Γ	Turning Seguence		Finish	Out of Sequence			

FAULT CATEGORY

General

Folio

Wave/Twist in Tube

Other
Process
Supplier
Training
Unapproved

Landing Gear

DART AEROSPACE LTD	Work Order:	101089
		7
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

			Re	Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.438	0.443		0.438	0.438	0,438	. 438		
В	1.745	1.755		1.750	11750	1.750	1,750		
С	3.495	3.505		3.500	350	3.500	3.500		
D	1.745	1.755		1.750	1750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.503	.501	.500	500		
G	0.257	0.262		0258	07.5%	0.258	,258		
Н	0.375	0.380		0.377	0.377	0.377	.377		
1	0.490	0.510		.500	. 500	.500	.501		
J	1.174	1.184		1-179	1:179	1:179	1,179		
K	0.558	0.578		1,57.8	.528	.569	.529		
L	1.174	1.184		1,179	1.179	1.179	1.179		
M	1.365	1.375		1/370	1370	1:370	1.370		
.: N	2.495	2.505		2.500	2500	2.500	2.500		*** · · · · · · · · · · · · · · · · · ·
0	4.119	4.129		4.122	4122	4122	4.124		
Р	0.115	0.135		1126	12%	.121.	126		
Q	0.115	0.135		0.132	0.132	0.132	135		
R	0.240	0.260		. 250	351	257	.250		
S	0.115	0.135		0-132	0.132	0.132	.131		
Ŧ	0.178	0.198		0.188	0-188	0/188	. 188		
U	3.210	3.250		3.227			3.228		
V	0.230	0.250		.238	3-727	3.727	. 238		
w	0.115	0.135		.732	.132	.132	.737		
X	0.307	0.312		310	309	304	.369		
Ÿ	0.760	0.765		0760	6710	-0766	760		
2 .	0.352	0.372		340	-361	361	362		
AA	0.470	0.530		0.500		050	.500		
AB	0.615	0.635		0.625	0.500 0.625	0675	, 425		
AC	0.053	0.073		0.063	0.063	0063	· b63		
AD	0.240	0.260		247	247	248	249		
AE.	1.500	1.520		1.512	1.5133	13/2	1510	- +	· ·
AF	0.115	0.135		0-132	0.137	0.132	.135		
AG	0.240	0.280		0.275	0.7575	0.275	1275		
AH	0.240	0.260		249	.244	.249	.248		
ÀI.	2.000	2.020		2,001	20015	2.001	2.000		<u> </u>
AJ	0.023	0.043		0 033	0.033	0.033	033		
<u> </u>		ept/Rejec	•	2035	2022	2023	· 03 3	 	

				<u> </u>	
Measured by:	Ofr	ork	Audited by	, 9 <u>-</u> 89	
Date:	2013-06-26.	13/04/22	Date:	13.6.29	

Rev	Date	Change	Revised by	Approved
В	02.09.27	Re-format; Added Rev. D	KJ	
Ç	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension Al	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM 10	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \
·F.	13.03.07	Dwg Rev updated	KJ W	1 20

DART AEROSPACE LTD	Work Order:	101089
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

A.	-		· · · · · · · · · · · · · · · · · · ·	Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	14	82	18	Ву	Date
Α	0.438	0.443		.438	.433	.438	.438		
В	1.745	1.755		1750	1,750	1,750	1.750		
C.	3.495	3.505		3,500	3,500	3,500	3,500		
D	1.745	1.755		1.750	1.750	1.750	1.75%		
E	7.990	8.010		8.00D	1.000	8.000	8,000		
o.F ₅	0.490	0.510		.501	500	.500			
G	0.257	0.262		, 258	.258		.258		
Н	0.375	0.380		-377	.377	.258	377		
1	0.490	0.510		-572/	.501	,501	. 50/		
. J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.51.9	.569	. 57.9	.569		
Ļ	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N:	2.495	2.505		2.500	2.500	2.500	2.500		
0	4.119	4.129		4.124	4.124	4.124	4.124		
Р	0.115	0.135		. 26	12%	1126	1121		
Q	0.115	0.135		. /35	.135	.135	135		
R	0.240	0.260		.251	251	,252	.252		
, S	0.115	0.135	•	.131	,132	131	1131		
T	0.178	0.198		188	.188	188	.188		
Ü	3.210	3.250		3.228	3.228	3.227	3.227		
V	0.230	0.250		.239	238	.238	.238		
W	0.115	0.135		.239	.737	./33	. 733		
Χ	0.307	0.312		.3/0	.3/0	.310	.310		
Y	0.760	0.765		740	760	760	.760		
Z	0.352	0.372		.320	.3/.0	.31.0	.360		
AA	0.470	0.530		, 50p	,500	500	. 500		
AB	0.615	0.635		.625	.625	.425	1.25		
AC.:	0.053	0.073		. 6/03	.063	· 0/3	.663		
AD	0.240	0.260		.249	.248	.247	,249		
ΑE	1.500	1.520		1.511	1.511	1.5125	1.5113		
AF	0.115	0.135		. 135	. 735	.)35	.735		
AG.	0.240	0.280		. 275	.275	225	,275		
AH	0.240	0.260		. 250	.249	249	249		
Al	2.000	2.020		2.001	2001	2.003	2.002		
AJ	0.023	0.043		633	2533	.033	. 033		
		ept/Rejec	:t	10-1			V		

*			
Measured by:	and a	Audited by	
Date	13/01/27	Date: 13.6.29	

09.27	Re-format; Added Rev. D	141	
	Re-Joinial, Added Nev. D	KJ	
10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
05.05	Added dimension Al	KJ/RF	
12.05	Added dimension AJ	: KJ/JLM 10	
03.07	Dwg Rev updated	KJ W	M
(05.05 12.05	05.05 Added dimension Al 12.05 Added dimension AJ	05.05 Added dimension Al KJ/RF 12.05 Added dimension AJ KJ/JLM

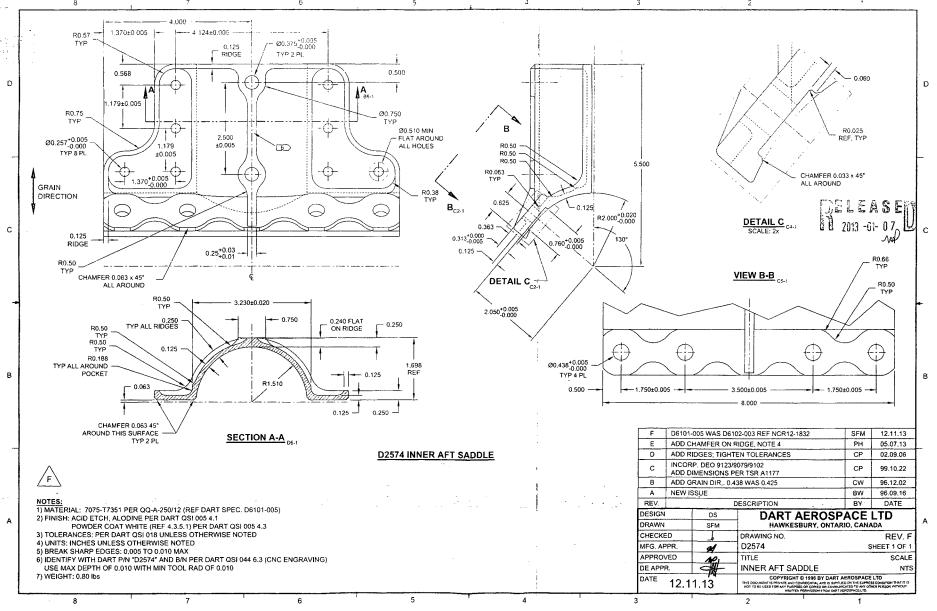
DART AEROSPACE LTD	Work Order:	101089
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. F	. 1	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

4.			Recorded Actual Dimensions						
Dim	Min	Max	Go/No Go Gauge	xq	210	3/11	1/2	Ву	Date
Α.	0.438	0.443	:	,258	, 258	.258	.257		
В	1.745	1.755		1.750	1.750	1.750	1,70		
C	3.495	3.505		3.500	3,500	3.500	3.50b		
D	1.745	1.755		1.750	1.750	3.950	1.750		
E	7.990	8.010		8.000	8,000	8.001	8.000		
F	0.490	0.510		,500	.5710	5702	.501		
G	0.257	0.262		.258	.258	.258	. 258		
Н	0.375	0.380		.377	.258	.377	.377		
ı	0.490	0.510		,500	.50/	502	.502		
J	1.174	1.184		1.170	1.179	1.179	1.179		
K.	0.558	0.578		.529	. 57.9	.57.9	.569		-
Ľ	1.174	1.184		1.179	1.179	1.179	1.179		
М	1.365	1.375		1.370	1.370	1.370	1370		
N.	2.495	2.505		2.500	2.500	2.500	2.506		
0	4.119	4.129		4,124	4.124	4.124	4.124		
Р	0.115	0.135		126	,126	121	126		
Q	0.115	0.135		1/35	135	.135	135		
R	0.240	0.260		.257	.251	.257	.251 .131 .188 3.227 .238		
S	0.115	0.135		.130	.130	.130	:131		
T	0.178	0.198		./88	188	.188	188		
ΰ	3.210	3.250		3.227	3.227	3,227	2 222		
V	0.230	0.250		.239	.239	.240	.238		
W	0.115	0.135		132	./32	.132	.132		
Х	0.307	0.312		.310	.310	310	310		
Ϋ	0.760	0.765		FLO	710	.760	760		
Z	0.352	0.372		. 3/10	.360	31.5	-360		
AA	0.470	0.530	· · · · · · · · · · · · · · · · · · ·	.500	,500	.500	.500		
AB	0.615	0.635		. 425	.625	.625	625		
AC	0.053	0.073		1043	1/23	-063	-063		
AD.	0.240	0.260		.242	247	.249	.246		
AE	1.500	1.520		1.5115	1.511	1.5115	1.512		
AF	0.115	0.135		135	.135	./35	./35		
AG	0.240	0.280		.275	.275	,275	.275		
AH	0.240	0.260		249	.249	250	249		
Al	2.000	2.020		2.0025	2.002	2.002	2.003		
AJ	0.023	0.043		.033	. 033	.033	,033		
		ept/Rejec					n n	0	

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Measured by:	Audited by
Date: 13/06/27	Date: (3. 2. 2.9

Rev	Date	Change	Revised by	Approved
В	02.09.27	Re-format; Added Rev. D	, KJ	
С	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D.	05.05.05	Added dimension Al	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM 10	NI .
F.	13.03.07	Dwg Rev updated	KJ W	<u> </u>
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